

Work Order ID 62428

September 30, 2010 7:59:49 AM



Page 1

Item ID: D4172-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Angle

Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 10/9/30 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4172	A								
100		0.00	<i>M-1 10/09/30</i>						
	Small Fab	0.00							
Small Fab	Memo								
	1- Cut to length as per dwg								
	2- Use DT9658 to drill holes in angle, open to size as per dwg								
	3- C'sink holes as per dwg								
	4- Deburr holes								
110	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00	<i>8.10.10.06</i>						
Quality Control	Memo								
120	Chemical Conversion Coat per QSI005 4.1	0.00	<i>10-10-6</i>						
	HandFinish	0.00							
Hand Finishing	Memo								

(X)

(X)
-4

(1)

PK →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4172-4 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 62428		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.10.01	100.2	HOLE SERIES PER DETAIL A SHIFTED BY 0.030" ON THE 5.500" DIA (CB-6). RC: JIG NOT PROPERLY PREPARED AT THE END STOPPER. FLASH OF WELDING PREVENTING FROM LOCATING PART CORRECTLY.		THIS DEVIATION IS ACCEPTABLE ON THE BASIS THAT THESE ALL THE HOLES ARE STILL WITHIN THE 0.010" FROM	M-A 10/10/05	S 10/10/06		S 10/10/06
			0.10.09	BUSH OTHER, FOR DRAWING. FURTHERMORE, THERE IS ENOUGH PLAY IN THE NOTPLATES TO COMPENSATE.		S 10/10/06	10.10.09 051042	S 10/10/06
10/10/01	± 100	Found at inspection that Dim .563 was measuring from one end .553 and the other .583 R.C. Jig is off.	10.10.04	SCRAP PARTS. CORRECT OR MAKE NEW DRILLING JIG PRIOR TO MAKING REPLACEMENT FOR SCRAPPED PARTS.	10.10.04 M-A 10/10/05	S 10/10/06	10.10.04	S 10/10/06

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		7/11		1	0		
140 Packaging Packaging	Identify as per dwg & Stock Location: <u>241A</u> Memo	0.00 0.00		10/10/06					10/10/06 SP
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/10/06 ME 10-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 62428



Parent Item: D4172-4



Parent Item Name: Support Angle

Start Date: 9/30/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A1.000W.125		Purchased	No			100	f	90.9100	6.25	6.578947			
6061T6 ANGLE 1.00 x 1.00 x .125W													



M-1 10/04/30

Location

MAT

Loc Qty

90.91

Loc Code

115688 ✓

10.91

115776

80

6.578947

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

